

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	STEP STRUT
Job Number	:	33204			
Estimate Number	:	11937			
P.O. Number	:	N/A	Part Number	:	D2017121
This Issue	:	6/27/2007 S.O. No. : N/A	Drawing Number	:	D2017 REV E1
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : SMALL /MED FAB	Drawing Revision	:	E1
Previous Run	:	N/A	Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	7/10/2007 Qty: 6 Um: Each
Checked & Approved By	:	<u>[Signature] 07.06.28</u>			
Comment	:	Est ID 02.06.19 Update processes (Ref. ECN 435) KJ/RF			

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:07:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 33204

Part Number: D2017121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

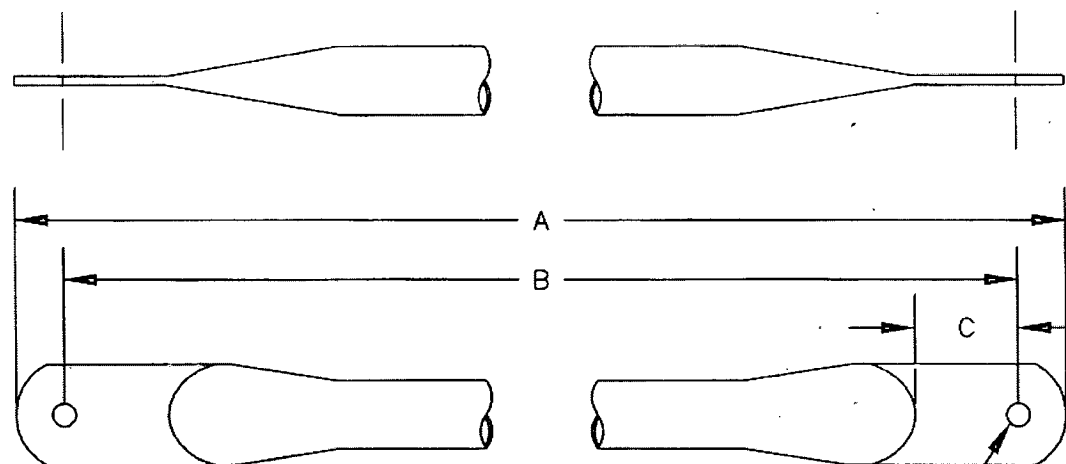
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



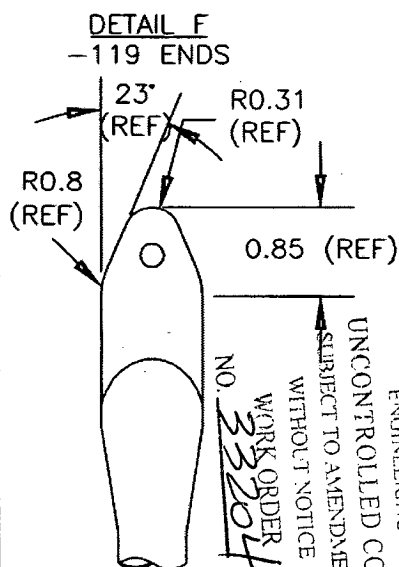
RELEASED
99.05.11 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		RF		HAINESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	KE	DRAWING NO.	REV. E
DATE	99.04.16			D2017	SHEET 1 OF 2
				TITLE	SCALE
				STEP STRUTS	NIS
C		95.01.26		ADDED PARTS	
D		96.03.28		ADD PARTS	
E		99.04.16		ENDS PUNCHED PER SPEC CTRL. -119 CHANGE (TSR A897)	
E1	02.03.22			ADD FINISH	



PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)

"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP/ 8° DOWN

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

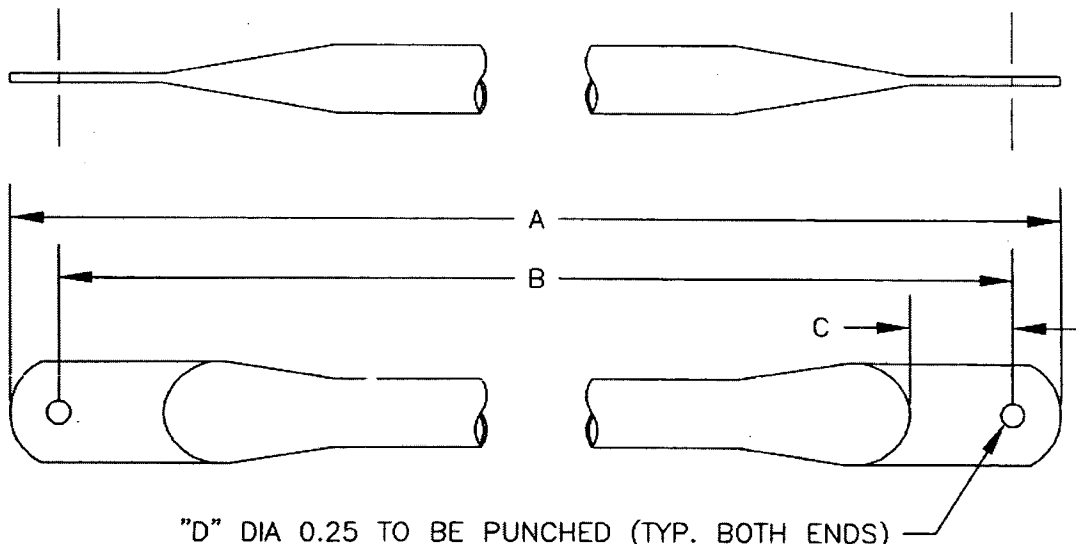
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 / E1

DART



DESIGN BW	DRAWN BY RT	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RT	DRAWING NO. D2017	REV. E
DATE 99.04.16	TITLE STEP STRUTS	SHEET 2 OF 2	
		SCALE NTS	

RELEASED
99.05.11 KE



Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

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WORK ORDER
NO. 33204

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

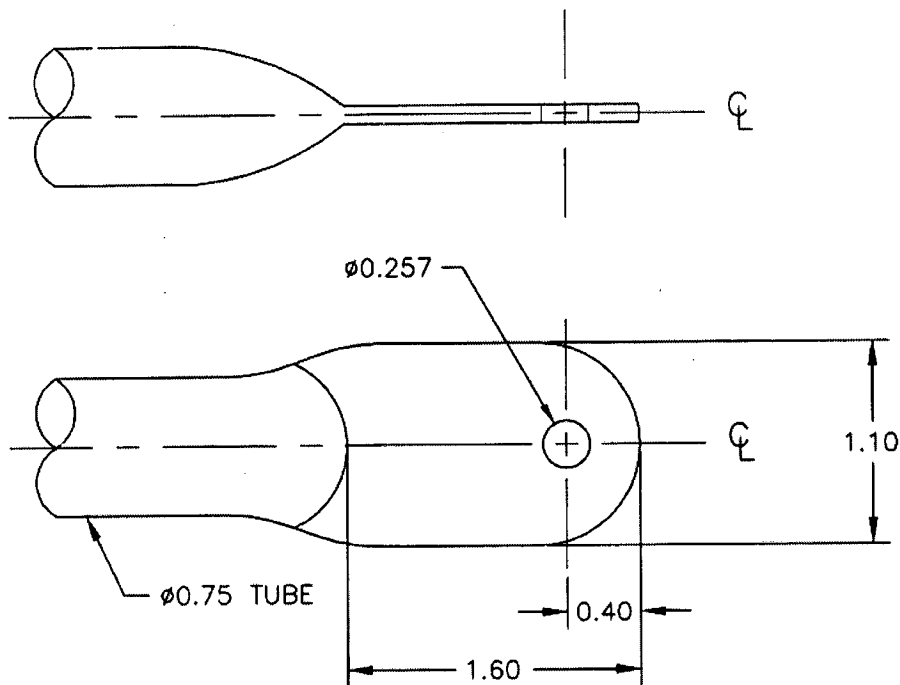
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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